

Date: Tuesday, 10/3/2006 3:47:50 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
Job Number : 28860	
Estimate Number : 10833	
P.O. Number : <i>N/A</i>	Part Number : D29331
This Issue : 10/3/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2933 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28669	Material : <i>N/A</i>
Written By : _____	Due Date : 10/30/2006 Qty: <i>8</i> Um: Each
Checked & Approved By : <i>SA 06.10.03</i>	
Comment : Est: B00.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: *SA 1525344*

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

SA 06.10.07

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

SA 06.10.08

4.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

SA 06.10.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *SD* Date: 06/10/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/3/2006 3:47:51 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 28860

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 06/10/10

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YZ 06/10/10 x8

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06/10/10 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 06/10/11 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57 475

P 06/10/11 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

P 06/10/11

Job Completion



U 06/10/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28860
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.124	.125	.124	.124		
C	0.100	0.140		.121	.122	.122	.123		
D	0.210	0.230		.220	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.495	2.495	2.495	2.495		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.122	.123	.123	.123		
O	0.540	0.560		.548	.550	.550	.550		
P	0.490	0.510		.496	.500	.495	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.251	.252	.251	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.125	1.145		1.134	1.1345	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	/	/	/	/		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SD
Date:	06.10.07

Audited by:	J.L
Date:	06/10/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28860
Description: 206 Saddle, Inboard, Left side	Part Number: D2933-1
Inspection Dwg: D2933 Rev. B	Page 1 of 1

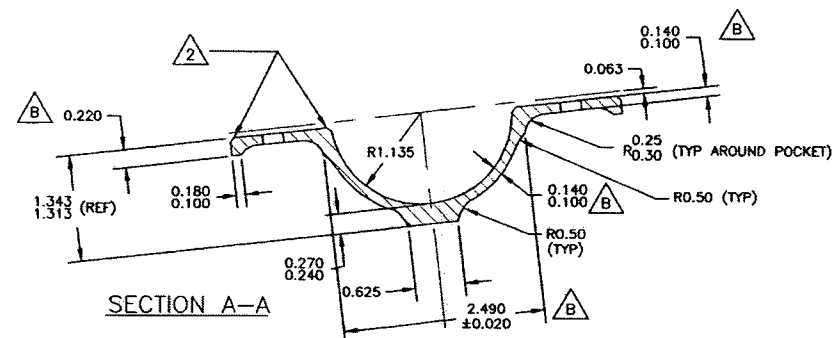
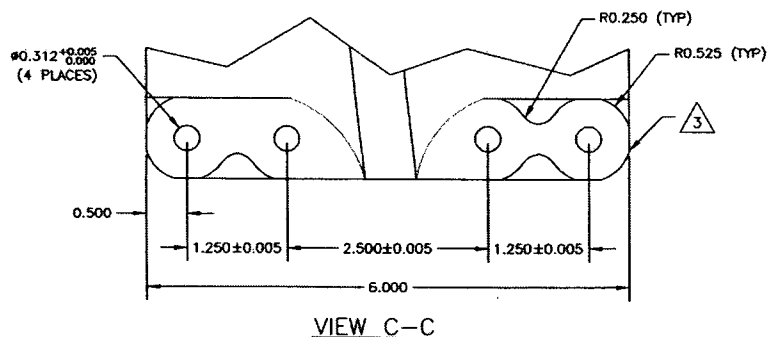
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.125	.125	.125		
B	0.100	0.140		.124	.124	.124	.124		
C	0.100	0.140		.122	.122	.123	.123		
D	0.210	0.230		.220	.230	.228	.220		
E	1.245	1.255		1.256	1.250	1.258	1.250		
F	1.245	1.255		1.258	1.250	1.258	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.495	2.495	2.495	2.495		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.235	.237	.238		
N	0.100	0.140		.122	.122	.122	.122		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.498	.497	.495	.496		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.252	.250	.257	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.315	.319	.315	.315		
X	1.125	1.145		1.134	1.134	1.1343	1.134		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
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AE									
AF									
Accept/Reject									

Measured by: SD
Date: 06.10.08

Audited by: J.L
Date: 06/10/10

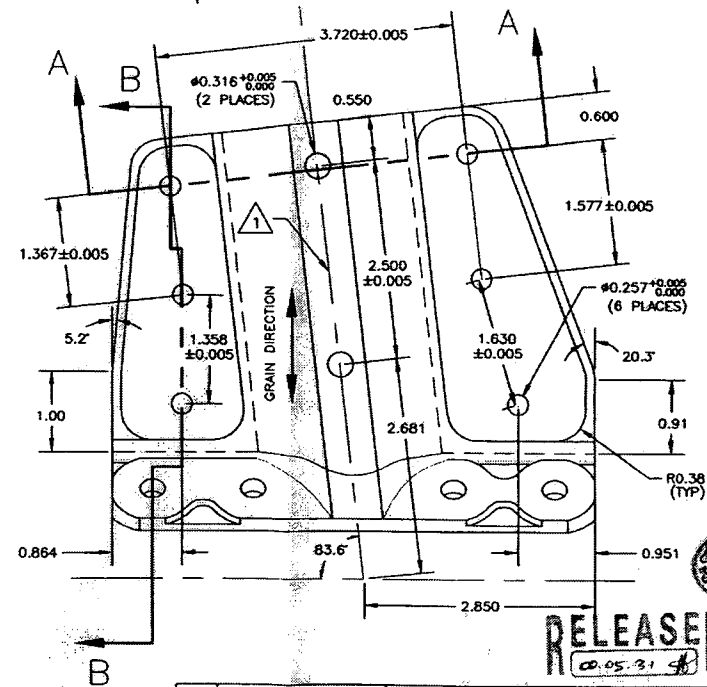
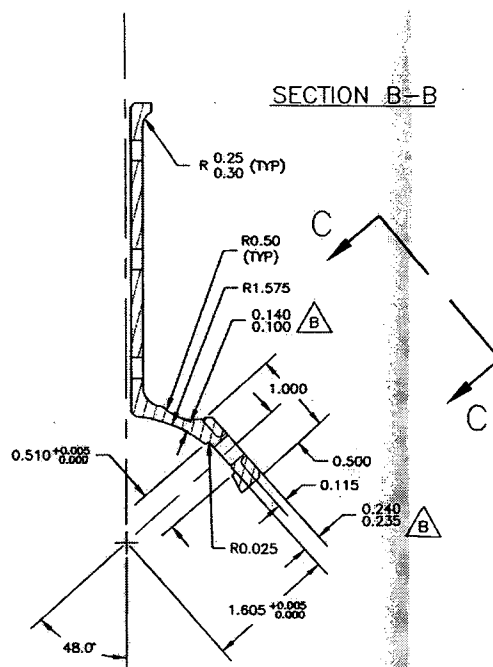
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D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



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 WORK ORDER
 NO. 28860

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 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE USA, INC.

B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	RF	DART DART AEROSPACE USA, INC. BOLIVUE, WA
CHECKED	APPROVED	DRAWING NO. D2933
DATE	00.05.29	TITLE SADDLE INSIDE
		REV. B SHEET 1 OF 1 SCALE 2:3